

# Work Order ID 101404

April-01-14 9:08:01 AM

\*101404\*

Page 1

Item ID: D350-600-241

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Spacepod™ Fwd Opening LH AS 350

Stop \*NS2\*

Start Date: 5/09/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00 \*1\*

Customer: CU-DAR001

Reference: RMA RA111508

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9639	A


100 0.00  
**\*100\***  
 QC  
 Quality Control

Memo  
 PULL FROM STOCK D350-600-241 X 1 B#64739

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT. CANADA K6A 1K7				TC APPROVAL # 08-39 TEL: 1-613-632-5200	
P/N	D350-600-241	CHG	CHG001		
DESC.	Spacepod LH	STC	SH93-88		
LOT	B64739	STC	SR00098NY		
MODEL	AS350	STC	SR00099NY		
MADE IN CANADA				02729-1	

110 0.00  
**\*110\***  
 Small Fab  
 Small Fab

Memo  
 DISASSEMBLE ALL HARDWARE AND DISCARD ALL NUTS, BOLTS & WASHERS  
*USE AIR Discard only used hardware*  
 SCUFF LIGHTLY AND REPRIME

*41 14-04-01 (x1)*  


120 0.00  
**\*120\***  
 QC  
 Quality Control

QC5- Inspect part completeness to step on W/O  
 Memo  
*DAS 27 9-89 14/4/15*

DQA:

Date: 14/05/02



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/4/30

Work Order update only ☐

Work Order: <u>101404</u>	<b>DISPOSITION</b> Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D350-600 1241</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3777</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other
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re-work/messing form

RA Rework Picklist

**Work Order ID 101404**

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**\*101404\***

Page 2

Item ID: D350-600-241

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00

**\*1\***

Customer: CU-DAR001

Reference: RMA RA111508

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Wing Walk as per dwg QSI005 4.4 Batch 128623 0.00**\*130\***

HandFinish

Memo

0.00

Hand Finishing

Wing Walk Spacepod top surface of Pod as per Dwg D3188

45 14-04-15 (y1)

140

QC3- Inspect Part Finish 0.00

**\*140\***

QC

Memo

0.00

Quality Control

bx d gl 14/04/15

150

0.00

**\*150\***

Small Fab

Memo

0.00

Small Fab

RE-ASSEMBLE USING ORIGINAL D-PARTS AND NEW HARDWARE

45 14-04-15

**Work Order ID 101404**

April-01-14 9:08:01 AM

**\*101404\***

Page 3

Item ID: D350-600-241

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/10/13

Req'd Qty: 1.00

**\*1\***

Customer: CU-DAR001

Reference: RMA RA111508

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

SMF  
14/4/15**\*160\***

QC

Memo

0.00

Quality Control

161

Pick Kit

0.00

**\*161\***

Packaging

Memo

0.00

Packaging

APR 22 2014

DAS  
31  
9-89

162

QC4- 100% Inspect kits for completeness

0.00

**\*162\***

QC

Memo

0.00

Quality Control

DAS  
06  
9-89

APR 22 2014

**Work Order ID 101404****\*101404\***

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April-01-14 9:08:01 AM

Item ID: D350-600-241

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00 **\*1\***

Customer: CU-DAR001

Reference: RMA RA111508

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>117</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00	LAS CG 9-39		APR 24 2014		<u>8</u>		
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

14-4-25

14-4-24

# Picklist Print

April-01-14 9:08:01 AM

Page 1

Work Order ID: 101404

**\*101404\***

Parent Item: D350-600-241

**\*D350-600-241\***

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

**Comments:** IPP Rev:A07.03.07 new issue ec  
 IPP rev B 07.04.16 reformat,D3188 revE ec IPP Rev:C  
 remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D  
 10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified  
 by: DD IPP Rev:E remove seq 130/140 now all in seq  
 150 DD 10.05.13 verf  
 :EC IPP REV:F  
 13.02.06 AS PER DSI9639 REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2985

Manufactured No

Each 21.0000

1

**\*D2985\***

Label

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST022

21

104987

9

106718

9

86719

3

D350-600-241

Manufactured No

Each 1.0000

1

**\*D350-600-241\***

Spacepod™ Fwd Opening LH AS 350

64739

**\*\***

14-04-15

Location

Loc Qty

Loc Code

FG118

1

70175

1

D350-600-449

Manufactured No

Each 1.0000

1

**\*D350-600-449\***

Switch Relocation

**\*\***

106720

Location

Loc Qty

Loc Code

FG125

1

105758

1

DAS  
06  
9-89

DAS  
31  
9-89

# Picklist Print

Page 2

April-01-14 9:08:01 AM

Work Order ID: 101404

\*101404\*

Parent Item: D350-600-241

\*D350-600-241\*

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

K10021

Manufactured No

Each

2.0000

**\*K10021\***

Spacepod Hardware (-241)

\*\*

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG125

2

97225

2

DAS  
31  
9-89

Winda  
D30871 x1

B 59334

DAS  
31  
9-89

DAS  
06  
9-89

April-01-14 9:08:01 AM

Shop Packet Print

Page 2

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.  
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A  
D3188-2 = N/A  
D3188-3 = N/A  
D3188-5 = N/A  
D3188-6 = N/A  
D3188-7 = N/A

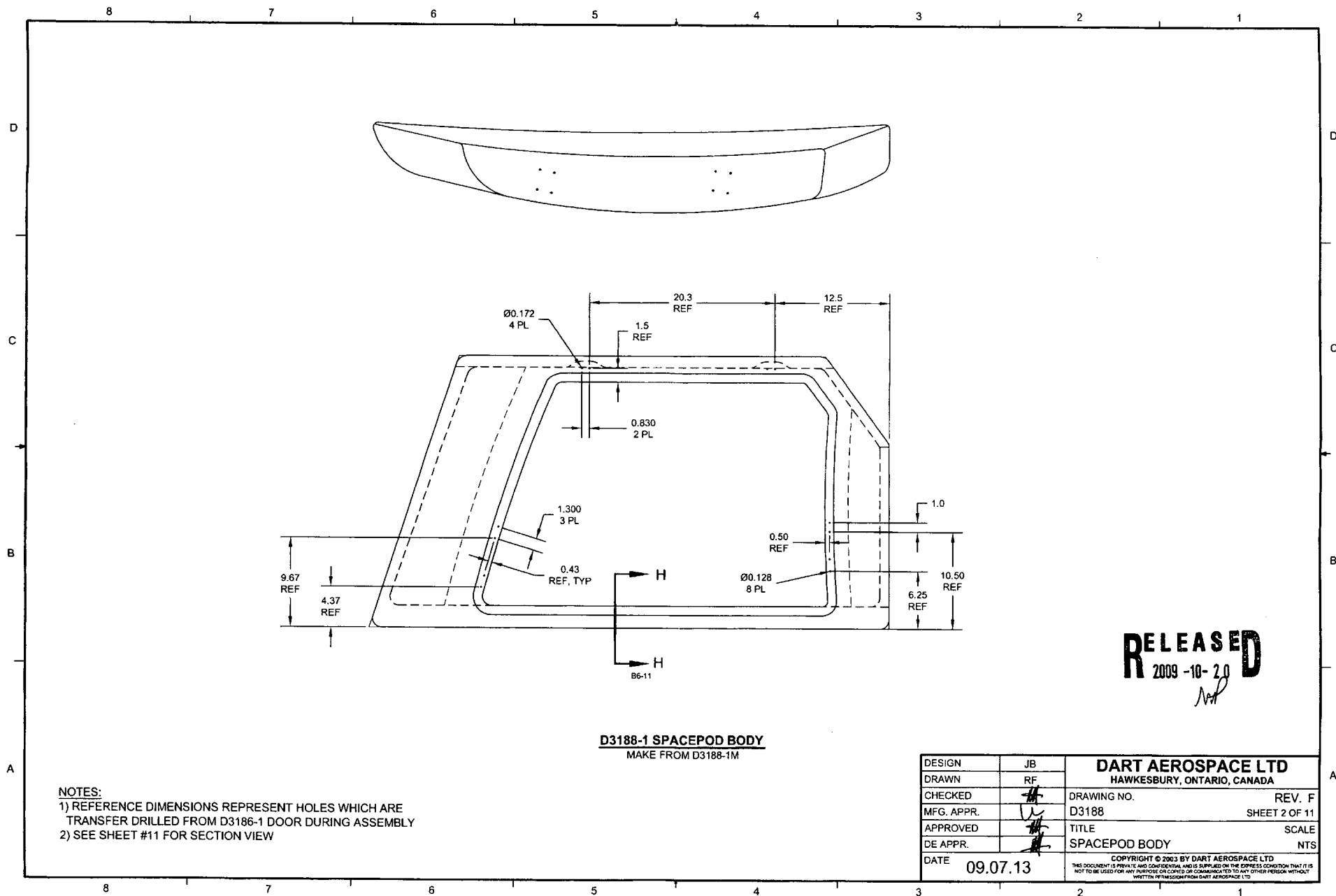
8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

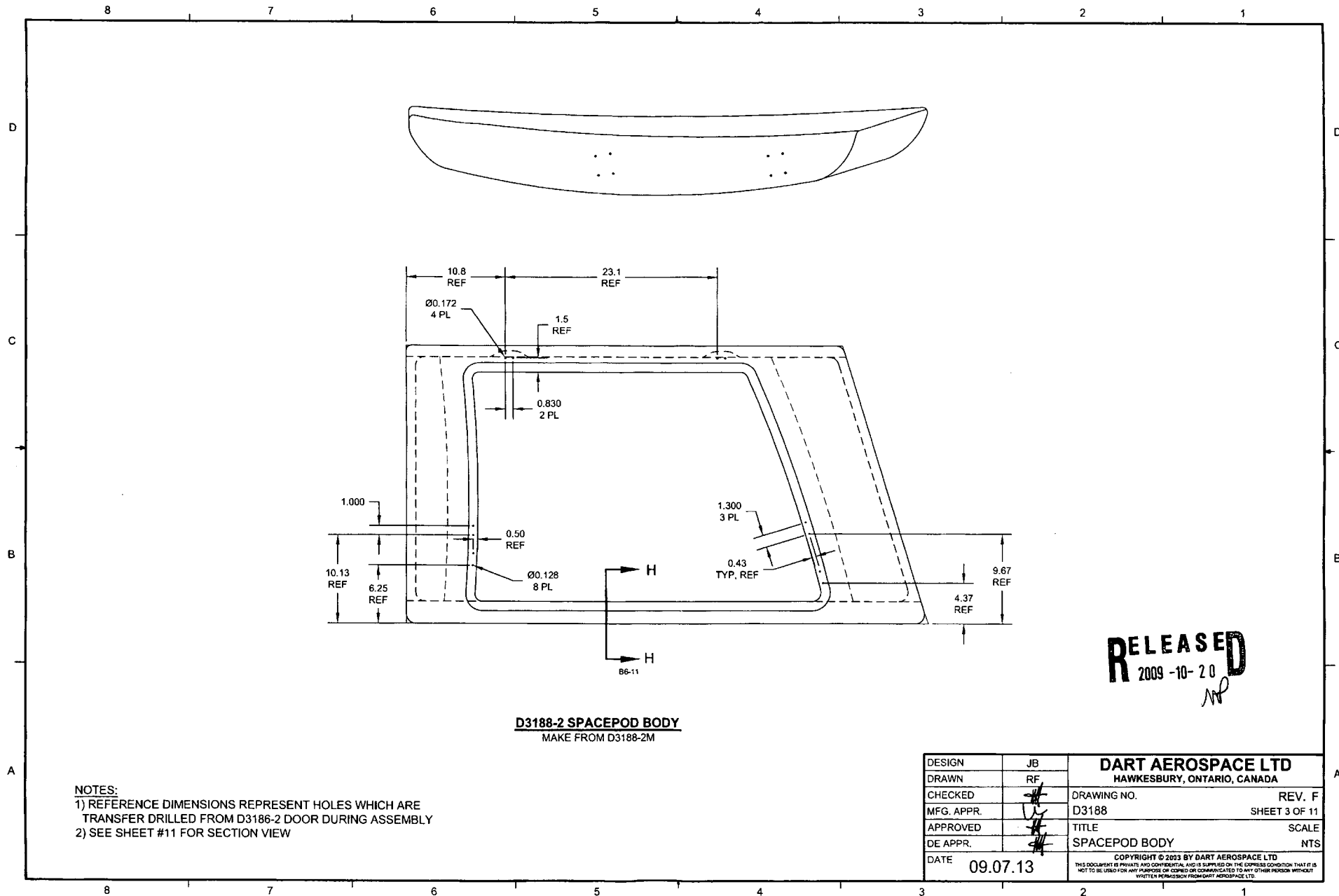
9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

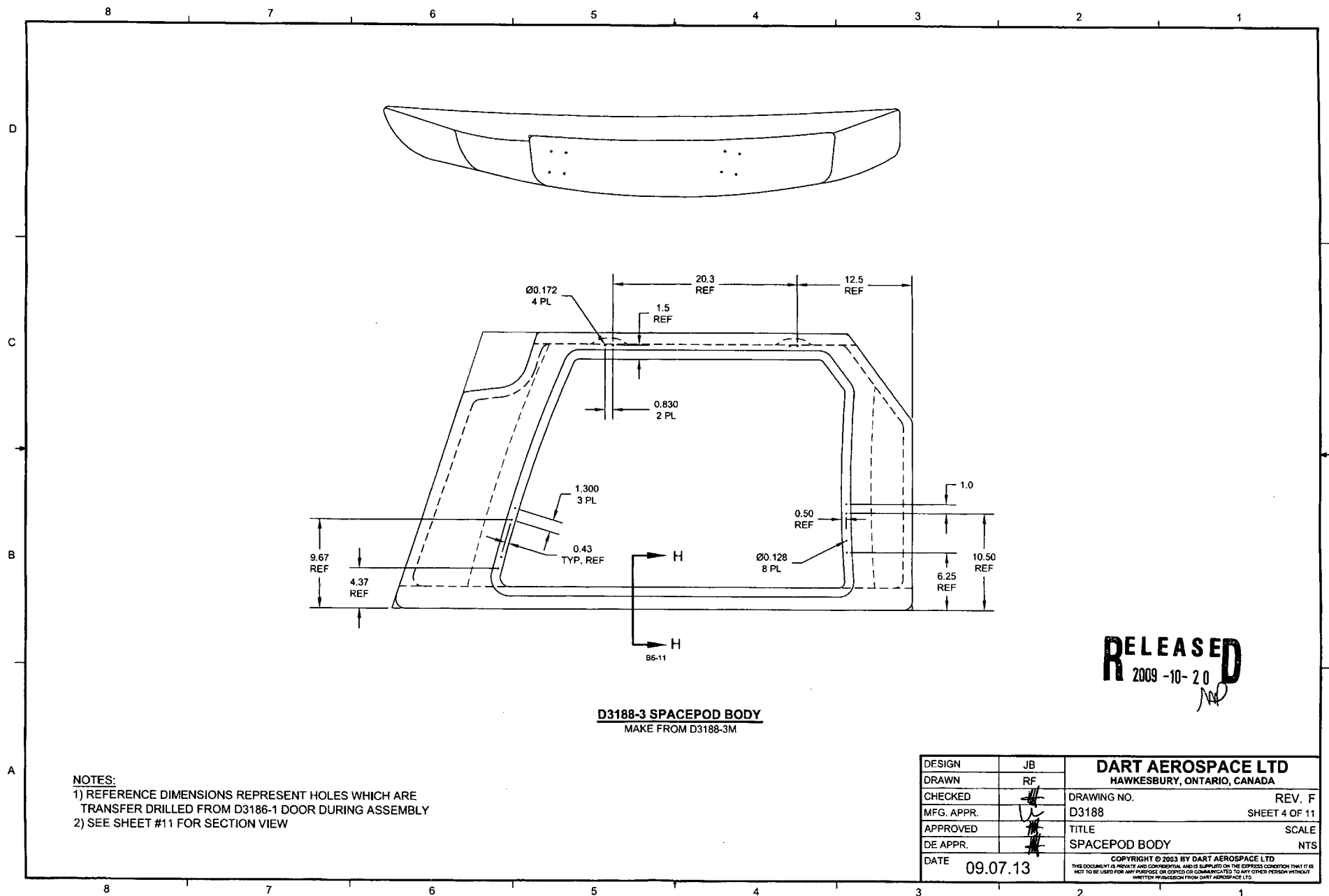
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2009-10-20

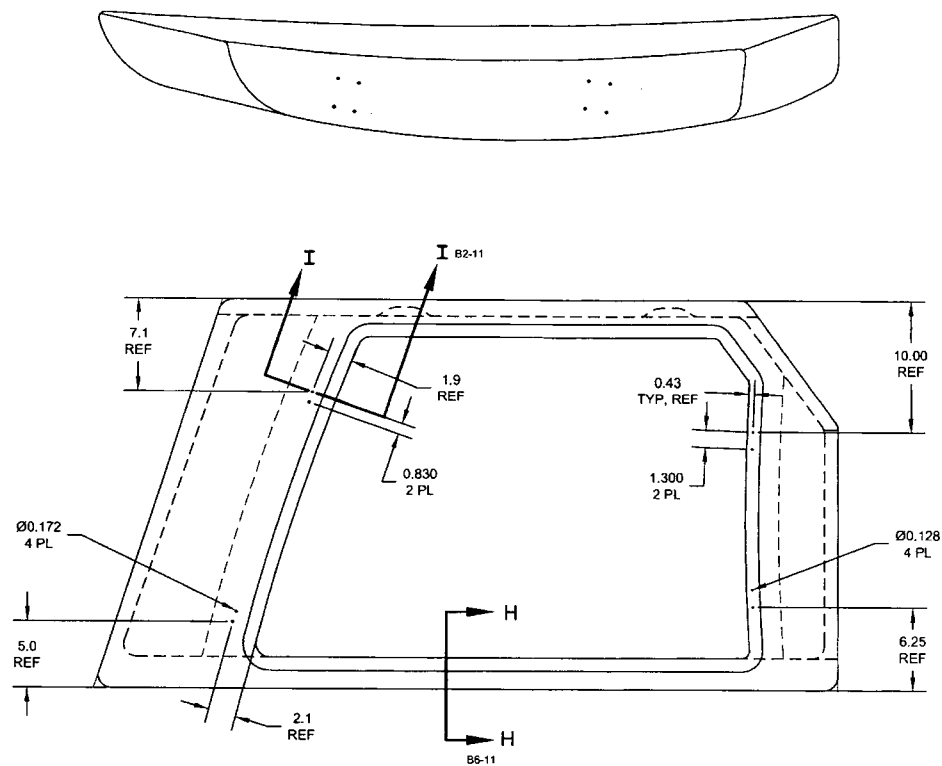
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>RF</del>	D3188	SHEET 1 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	











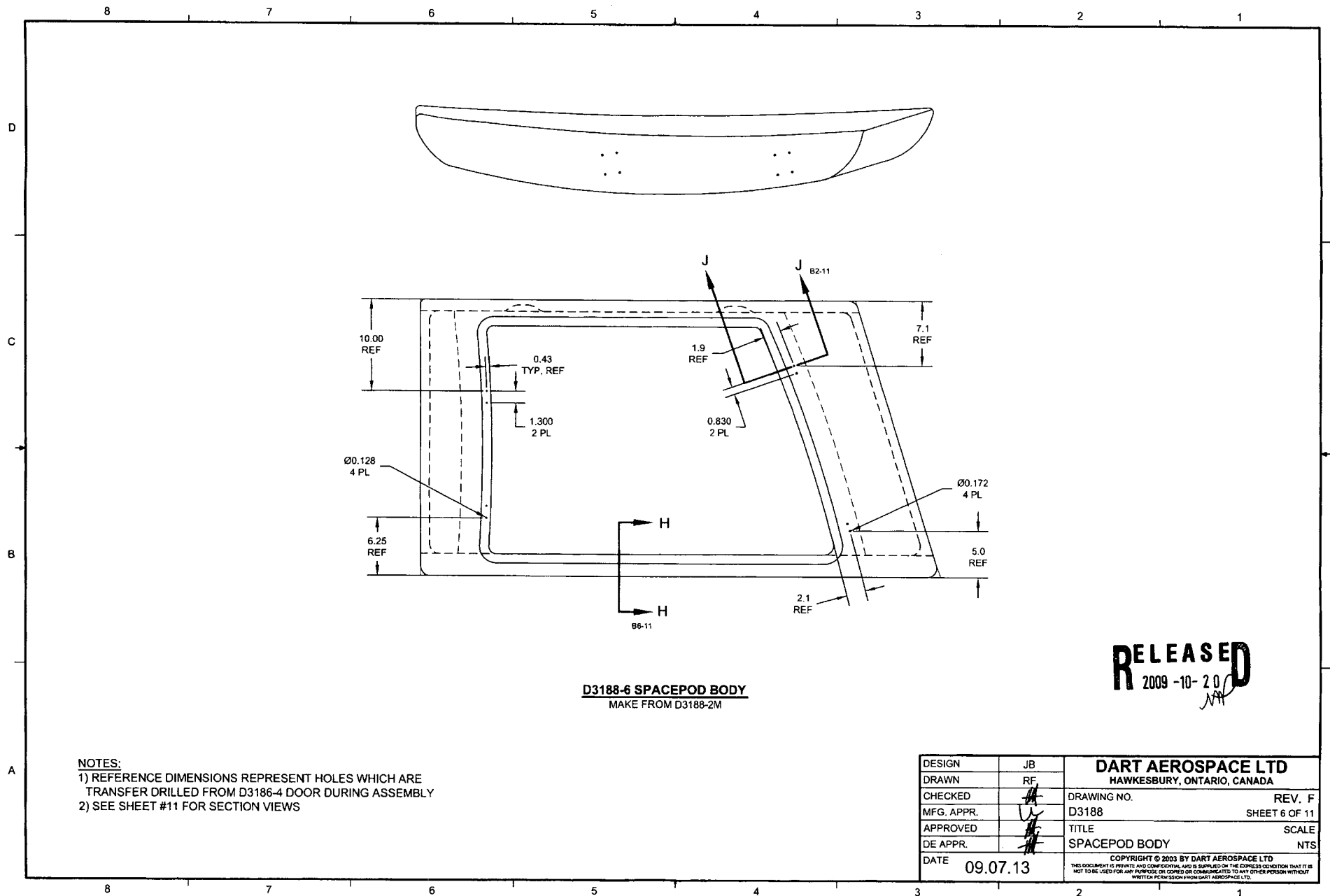
**D3188-5 SPACEPOD BODY**  
MAKE FROM D3188-1M

**NOTES:**

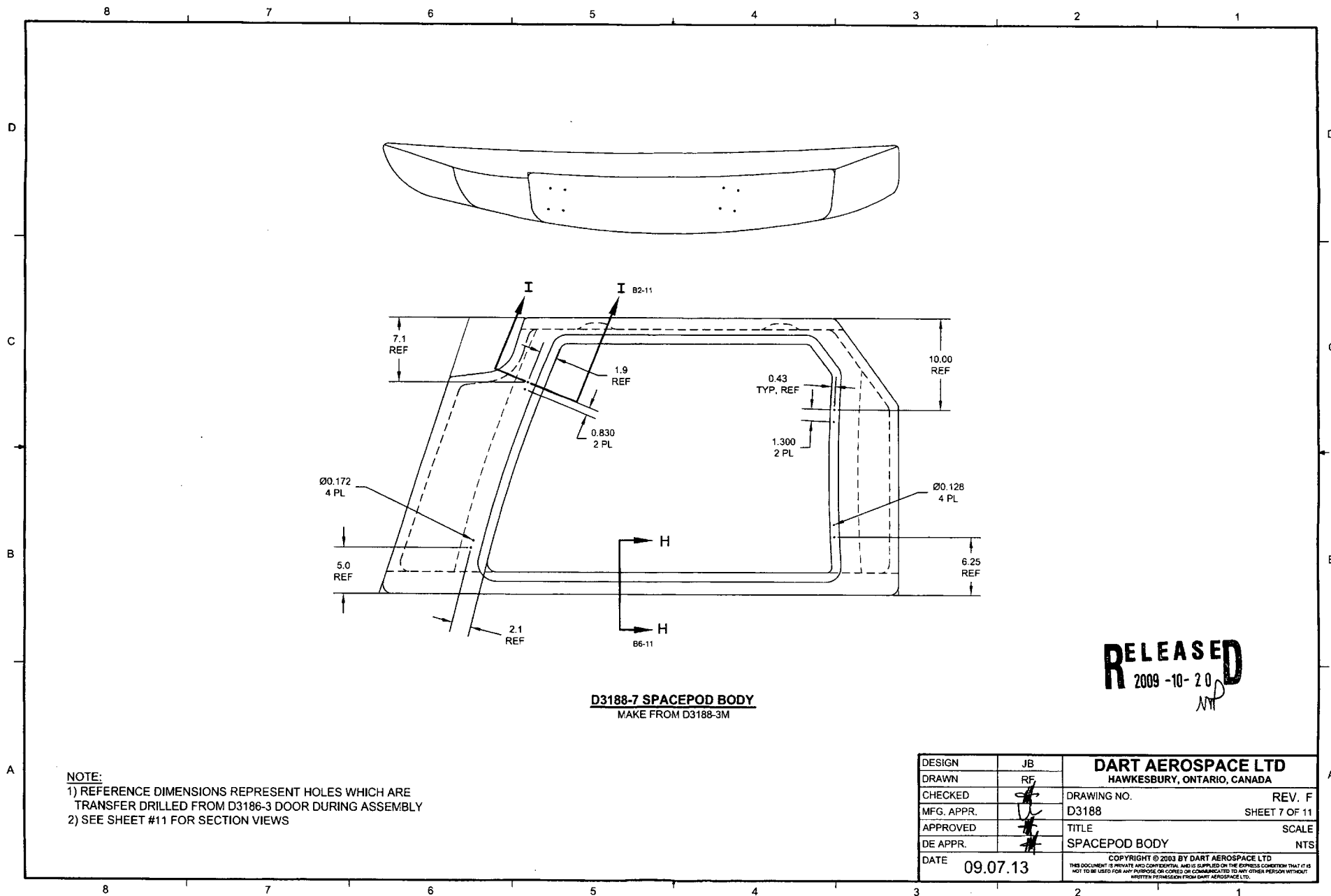
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

**RELEASED**  
2009-10-20  
*MD*

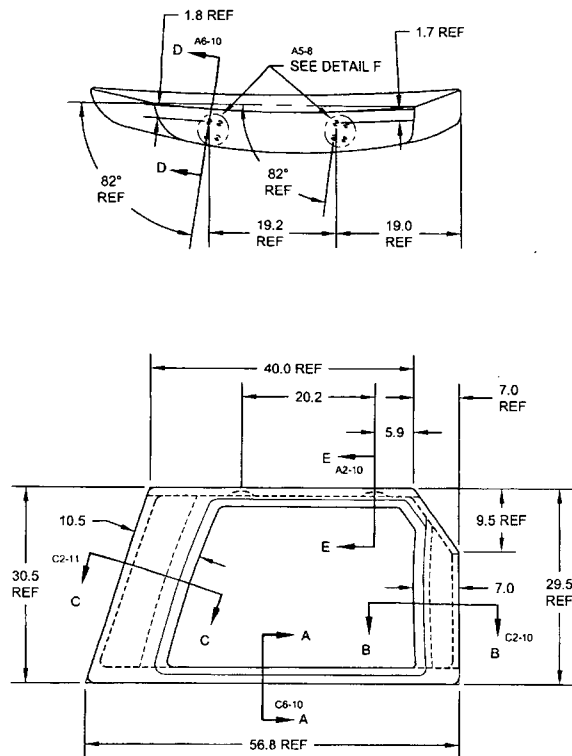
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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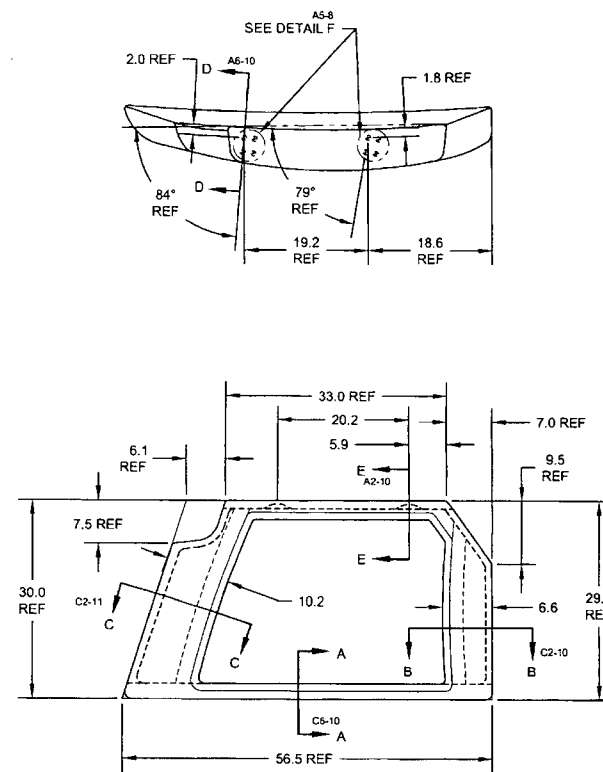
**RELEASED**  
2009-10-20  
*[Signature]*



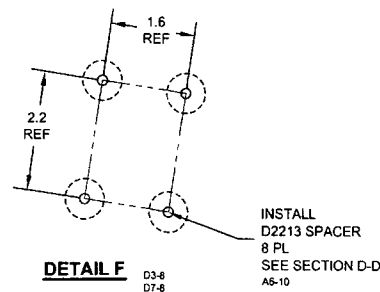
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2009-10-20  
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**D3188-1M SPACEPOD BODY**







**D3188-3M SPACEPOD BODY**

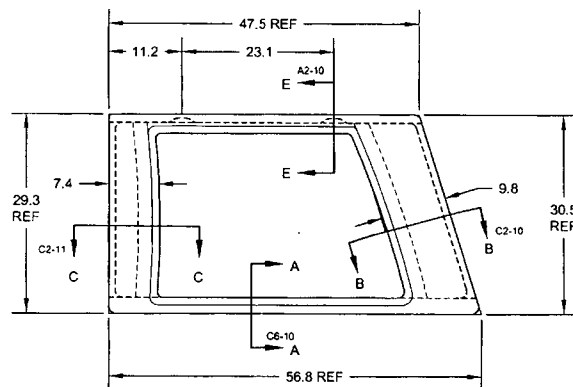
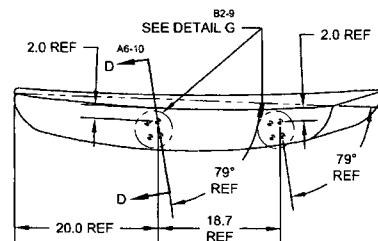


**DETAIL F**

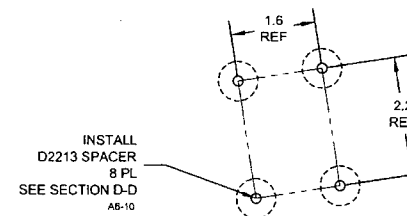
- D3188-1M/-3M NOTES:**  
 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.  
 2) SEE SHEET #10 FOR SECTION VIEWS.

**RELEASED**  
 2009-10-20

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
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**D3188-2M SPACEPOD BODY**



**DETAIL G** D6-8

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2009-10-20

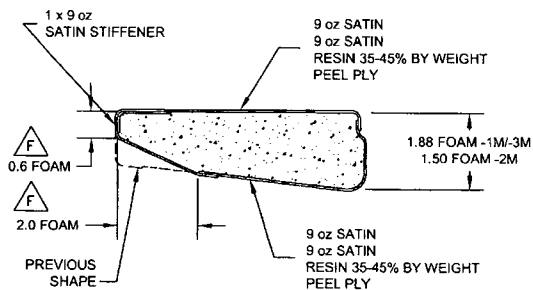
**D3186-2M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

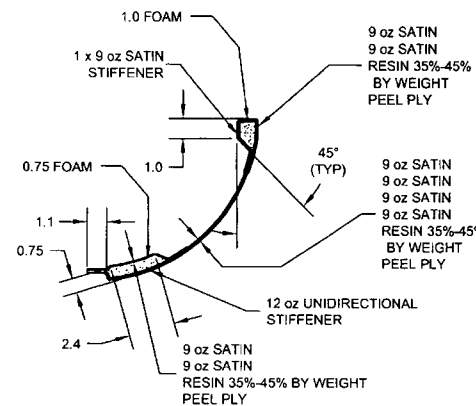
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>JB</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>JB</del>	D3188	SHEET 9 OF 11
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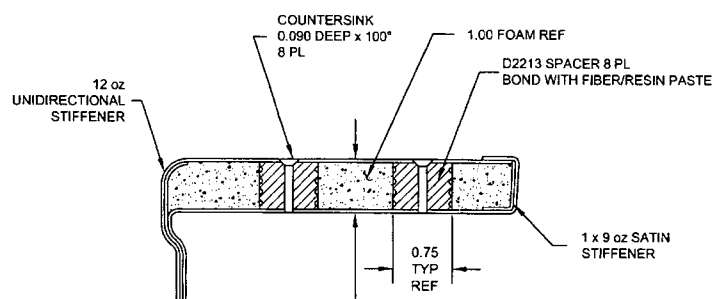
OUTBOARD



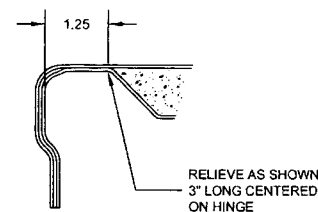
**SECTION A-A**  
TYPICAL FLOOR SECTION  
B7-8  
B3-8  
B6-9



**SECTION B-B**  
SECTION C-C OPPOSITE  
B6-8  
B8-8  
B4-8  
B2-8  
B7-9  
B5-9



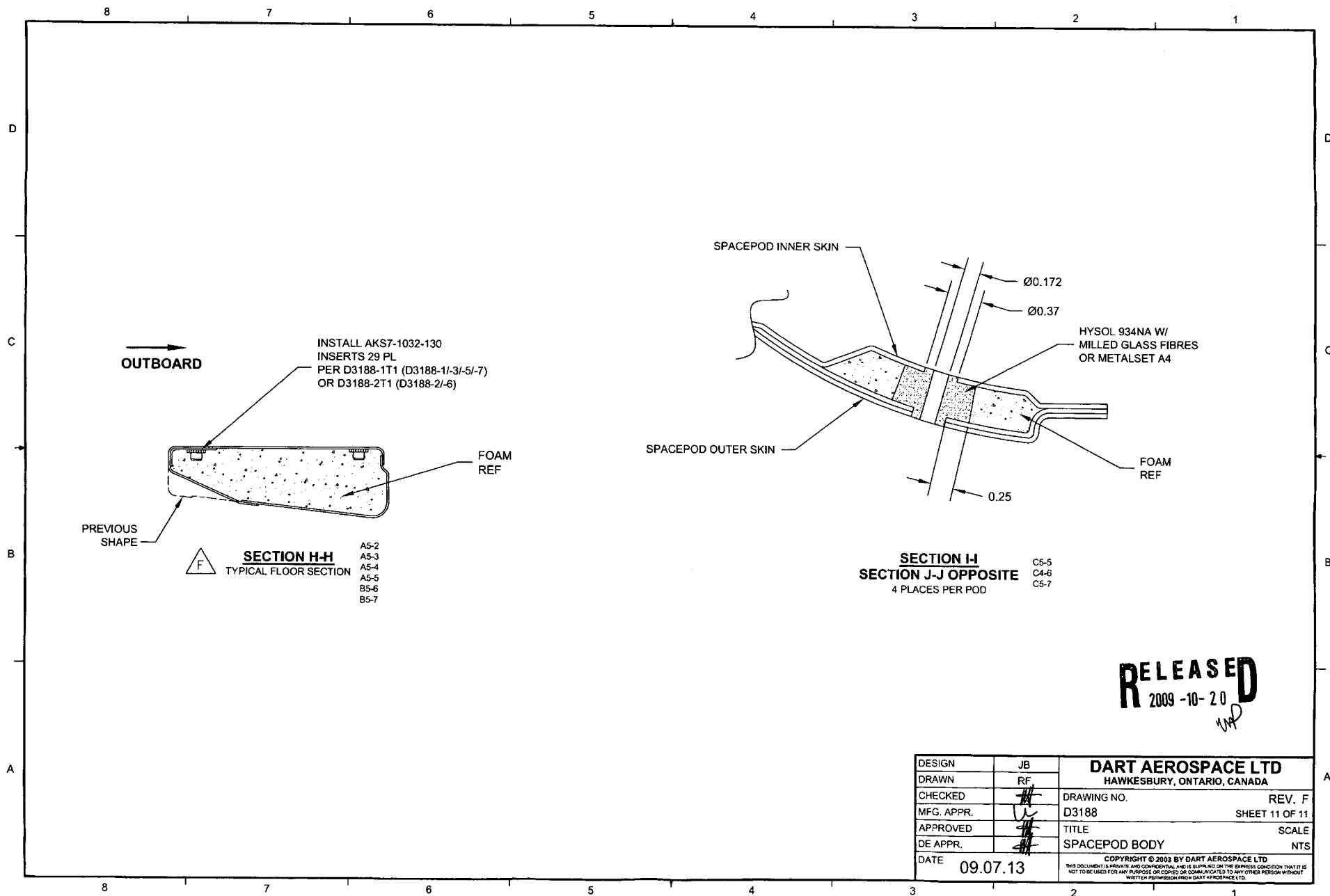
**SECTION D-D**  
TYPICAL ROOF SECTION IS SIMILAR  
BUT WITHOUT INSERTS  
D3-8  
D7-8  
D6-9



**SECTION E-E**  
2 PLACES PER POD  
C2-8  
C7-8  
B6-9

**RELEASED**  
2009-10-27

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>RF</del>	D3188	SHEET 10 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NTS
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8 7 6 5 4 3 2 1

D

D

C

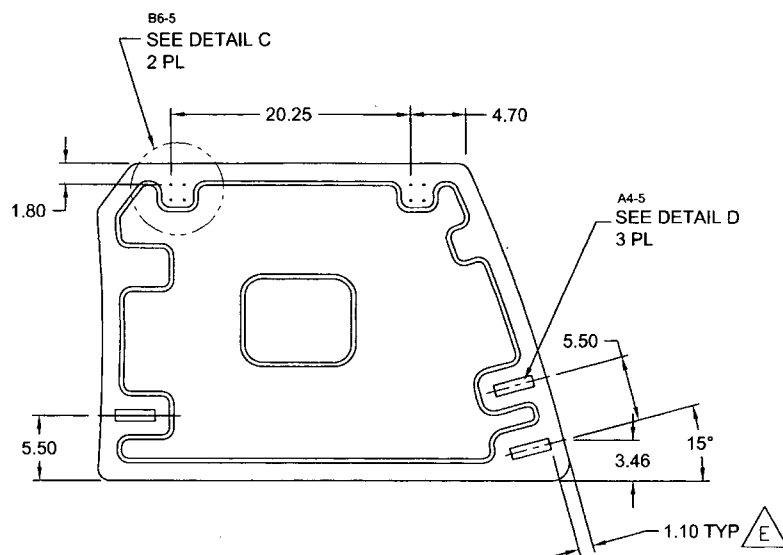
C

B

B

A

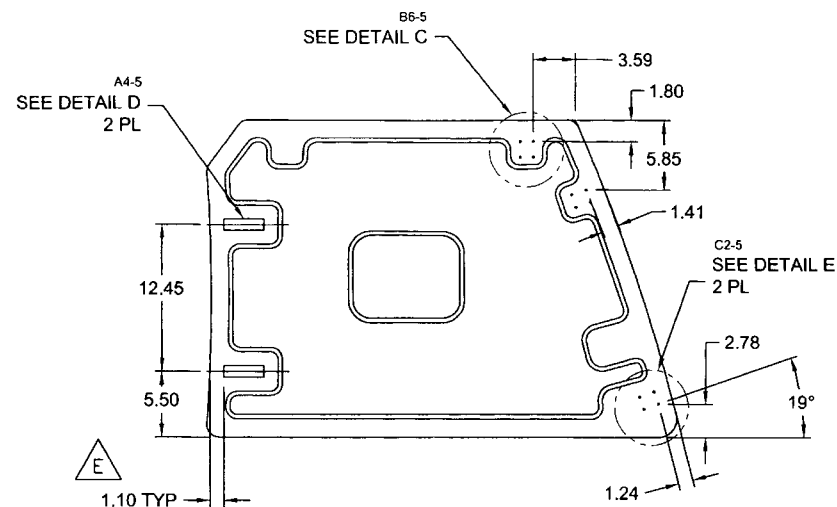
A



**D3186-1 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

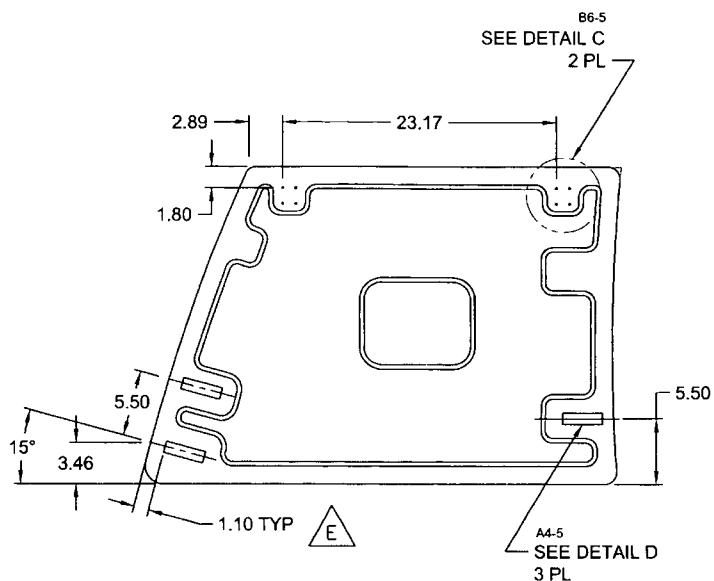


**D3186-3 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

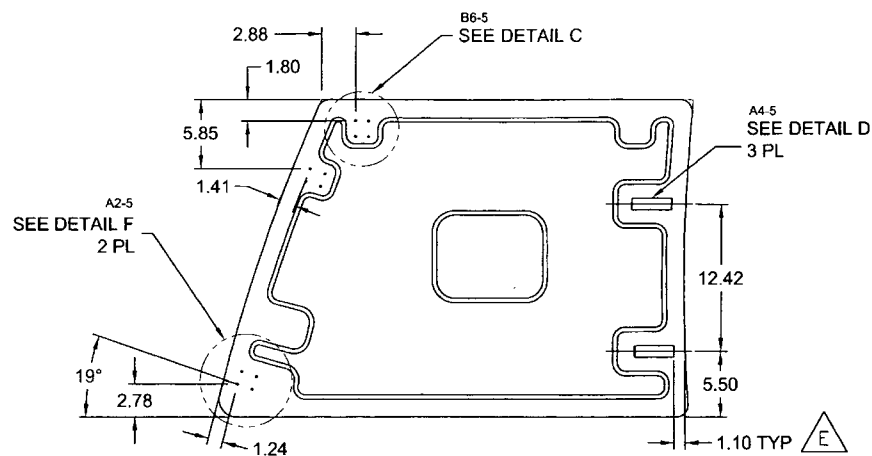
**RELEASED**  
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/2M/3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



**D3186-2 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M







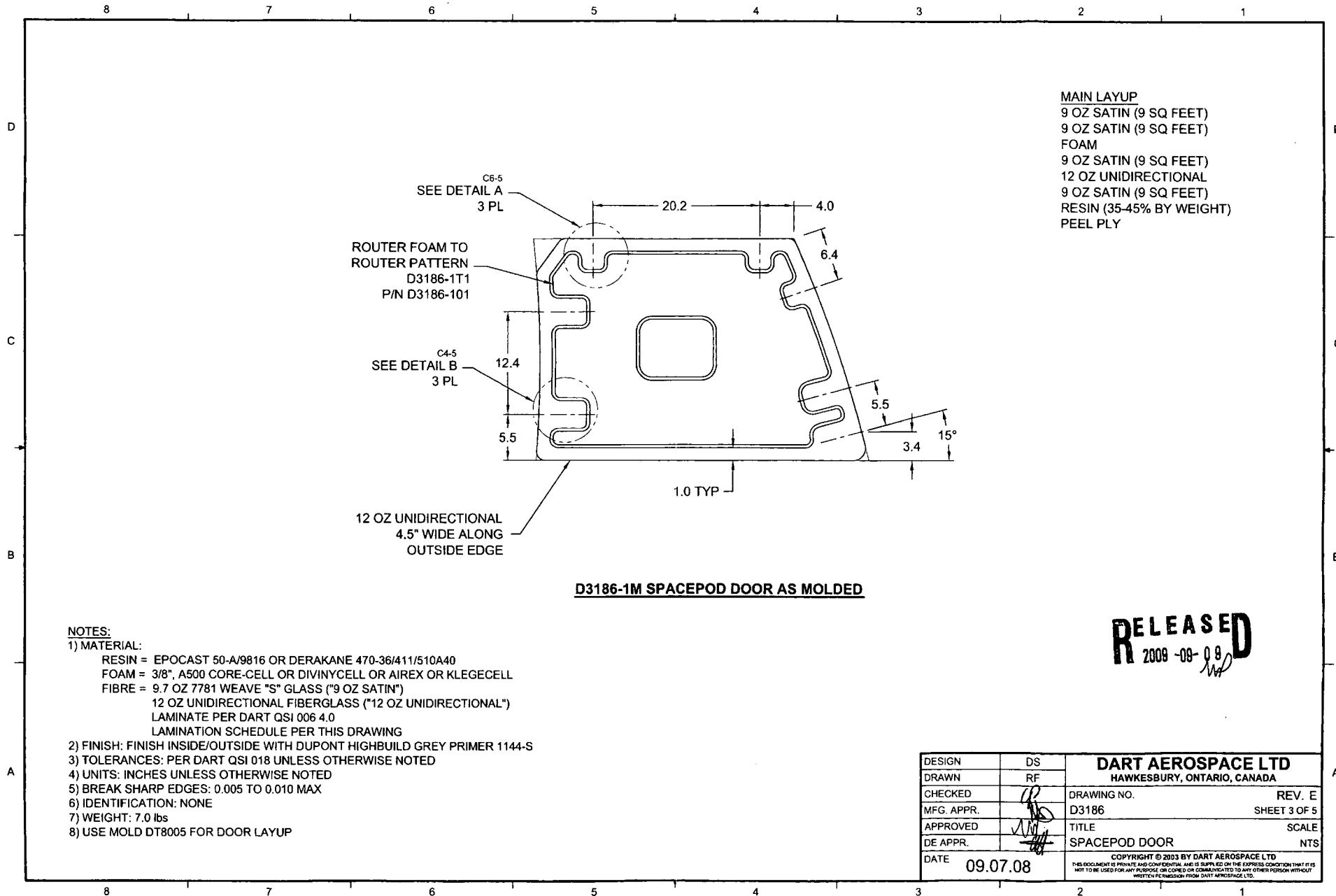
**D3186-4 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M

**RELEASED**  
2009-09-09

**NOTES:**

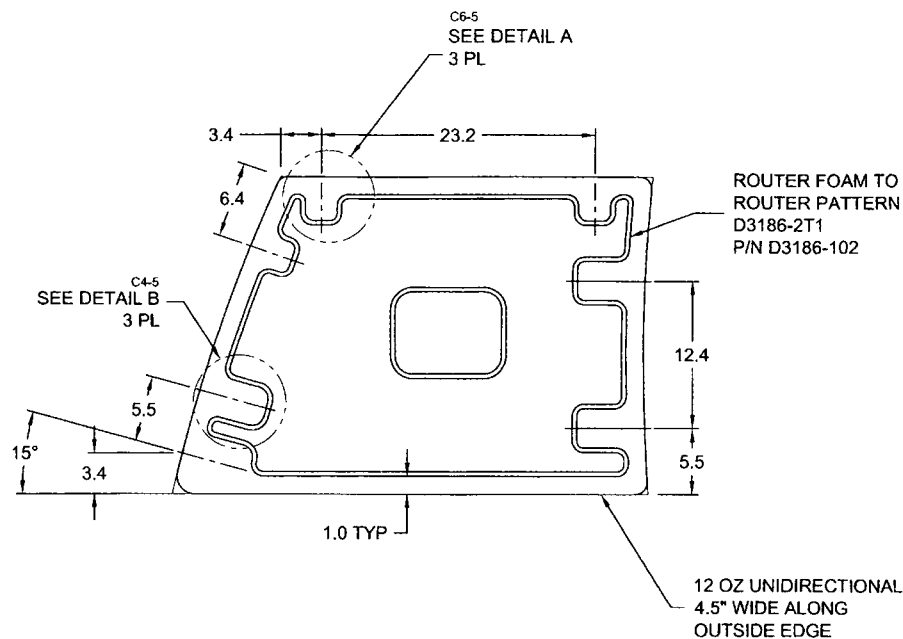
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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# MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



## NOTES:

### 1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

## D3186-2M SPACEPOD DOOR AS MOLDED

**RELEASED**  
2009-09-09

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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Neoprene seal

MS21042 L08 nut x2

NAS1515 H3 washer x2

MS27039-1-15 screws x2

3567-1 decal x1

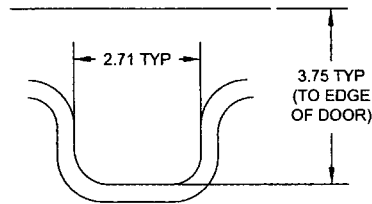
AN960508/NAS1149DN8325 washer x4

**Spacepod™**

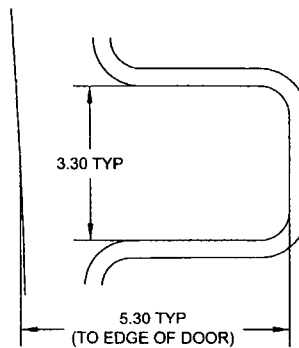
MAXIMUM DISTRIBUTED LOAD  
IN THIS COMPARTMENT  
364 lb / 165 kg

Decal P/N D3567-1

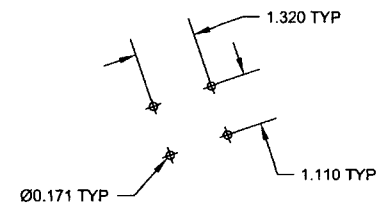
8 7 6 5 4 3 2 1



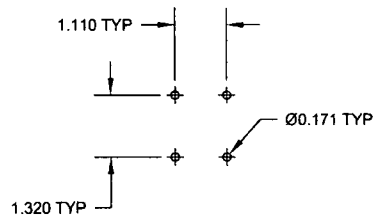
**DETAIL A** D6-3  
SCALE 4X D4-4



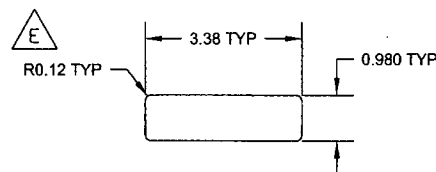
**DETAIL B** C6-3  
SCALE 4X C6-4



**DETAIL E** C1-1  
SCALE 4X

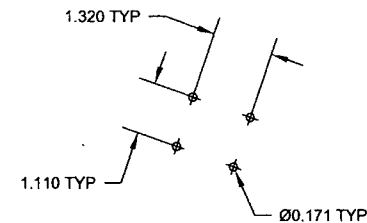


**DETAIL C** D7-1  
SCALE 4X D3-1  
D6-2  
D3-2







NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D** C5-1  
SCALE 4X D4-1  
B6-2  
C2-2



**DETAIL F** C4-2  
SCALE 4X

**RELEASED**  
2009-09-09

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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8 7 6 5 4 3 2 1



REPRINT

Work Order ID 101404

April-01-14 9:08:01 AM

\*101404\*

Page 1

Item ID: D350-600-241  
Revision ID:  
Item Name: Spacepod™ Fwd Opening LH AS 350  
Start Date: 5/09/13 Start Qty: 1.00  
Required Date: 5/10/13 Req'd Qty: 1.00  
Reference: RMA RA111508

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer: CU-DAR001

Approvals: Process Plan: W Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

DSI9639	A
---------	---

100  
\*100\*  
QC  
Quality Control  
Memo  
PULL FROM STOCK D350-600-241 X 1 B#64739

0.00

0.00

110  
\*110\*  
Small Fab  
Small Fab  
Memo  
DISASSEMBLE ALL HARDWARE AND DISCARD ALL NUTS, BOLTS & WASHERS  
SCUFF LIGHTLY AND REPRIME

0.00

0.00

120  
\*120\*  
QC  
Quality Control  
Memo  
QC5- Inspect part completeness to step on W/O

0.00

0.00

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7		TC APPROVAL # 08-89 TEL: 1-613-632-5200	
P/N	D350-600-241	CHG	CHG001
DESC	Spacepod LH	STC	SH93-88
LOT	B64739	STC	SR00098NY
MODEL	AS350	STC	SR00099NY
MADE IN CANADA		D2729-1	

MCS

14-04-27

14-04-01 (4)  
P40